

Order ID 110472

110472

Page 1

Item ID: D350-636-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 1/03/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLS Date: 13-12-20 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2750-041	G
-----------	---

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

record fwd angle: 89.5°

Photocopy blue file and type labels per PPP D350-636-011 CHG 007

DAS
31
9-89

14-03-04

1

DD 14-1-22

77-14-1-23

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Item ID: D350-636-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Stop ***NS2***

Start Date: 12/20/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/03/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

110

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside. AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. *****SECOND SIDE*****

8- Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail C to 0.500" (8 holes per side)

9- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297"

10- Open up holes of Detail A to 0.297" (total of 2 holes per side)

DP 14-1-22

- ac 14/01/23

DP 14-1-22

- ac 14/01/23

DP 14-1-22

- ac 14/01/23

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Item ID: D350-636-011**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Skidtube LH Aerazur / Apical Cylindrical Compat.**Start Date:** 12/20/13 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 1/03/14 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left
from bending as per QSI 004A/R Aluminum Rod batch 7127069*> BE14/01/23*

12-Grind welds flush as per Dwg D2750

120

QC10- Inspect visual per QSI004- ground welds 0.00

120

QC

Memo

0.00

Quality Control

DAS
9
9-89*① 14-01-24*

130

QC5- Inspect part completeness to step on W/O 0.00

130

QC

Memo

0.00

Quality Control

DAS
9
9-89*① 14-01-24*

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Item ID: D350-636-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.
 Start Date: 12/20/13 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/03/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
160									
Skidtubes	Memo	0.00							
Skidtubes	1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2-Open up holes of Detail B to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3- Open float hole to 0.500" (4 per side)								
	4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8)								
	5-Deburr and blow out all chips from inside of tube								
	6- Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI 015 A/R Sikaflex-291 batch: <u>123057</u> exp. date: <u>14-8-16</u>								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: <u>m127069</u>								
	9- At section AJ-AJ drill out x-bolt spacer to 0.404"								
	10- Grind welds flush as per Dwg D2750								

14-1-27 DGC

14-1-27 DGC

706 14-01-28

- mm 14/01/29

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Item ID: D350-636-011 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13 Start Qty: 1.00 *1* Cust Item ID:

Required Date: 1/03/14 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750								
	12-Debur holes								
170	QC10- Inspect visual per QSI004- ground welds	0.00							DAS 9 9-89
170	Memo	0.00							① 14-01-29
QC									
Quality Control									
180	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
180	Memo	0.00							① 14-01-29
QC									
Quality Control	***VERIFY C'BOARD IS GOOD***								

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 Required Date: 1/03/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00				1	28	14-1-29	
100	HandFinish	0.00							
Hand Finishing	Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200		0.00				1	0	0	AB
200	SprayPaint	0.00							14-2-22
Spray Painting	Memo 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: <u>126543</u> 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: <u>128198</u>								
210	QC14- Inspect Spray Paint	0.00				1			14-02-24
210	QC	0.00							
Quality Control	Memo Inspect for foreign object per QSI 024								

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Start Date: 12/20/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/03/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
230	HandFinish	0.00							
Hand Finishing	Memo 1- Install inserts as per Dwg D2750 2-Inspect for Foreign Objects 3- Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>1417918</u> EXP DATE: <u>1402</u> 4- Assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>14121651</u> 5- Coat all exposed fasteners with "LPS Procyon" batch: <u>1412290x</u>								
240	QC5- Inspect part completeness to step on W/O	0.00							
240	QC	0.00							
Quality Control	Memo								

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

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Start Date: 12/20/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/03/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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280	QC21- Final Inspection - Work Order Release	0.00							
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280

QC Memo

0.00

Quality Control

1/4-03-6

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D350-636-011

Start Date: 12/20/13**Required Date:** 1/03/14**Start Qty: 1.00**

Required Qty: 1.00

Comments:	IPP Rev:I	02.09.25	Rearranged procedure steps	KJ
	IPP Rev:J	06-03-23	As per Rev D	JLM
	IPP Rev:K	06-07.13	As per dsi9343	EC
	IPP Rev:L	07-07-28	Added SS Wearplates(Rev E)	JLM Verf:EC
	IPP Rev:M	08-04-22	update steps 4, 13	DD verified by:EC
	IPP Rev:N	08-09-23	revF as per dwg	DD verified by:ec
	IPP Rev:O	09-02-06	apply antiseize on AN8C21A bolts as per PAR09-010	
	DD verf:EC			IPP Rev:P 10.06.22 revise
	seq110 DD verf:EC			IPP Rev:Q 10.10.01 as per IIN revH
	DD verf:EC		IPP REV:R 13.08.27	PER ECN13-594 DD
	VERF:JLM			

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3492-1 *D3492-1* Plug		Manufactured	No			230	Each	195.0000	8	8		11/02/26	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP001		195							
				104844		195							
D3492-3 *D3492-3* Plug		Manufactured	No			230	Each	277.0000	8	8		11/02/27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP001		277							
				104853		72							
				107331		105							
				<u>109800</u>		100							
NAS1611-010 *NAS1611-010* O-RING		Purchased	No			230	Each	45.0000	8	8		11/02/26	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP001		45							
				m126988		45							

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Work Order ID: 110472

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Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0863J

Purchased

No

250

Each

991.0000

2

2

NAS1149D0863.J

-Washer

DAS
28
9-89

14-03-4

DAS
31
9-89

Location

Loc Qty

Loc Code

FP001

6

123900

118078

6

ST293

185

125484

185

ST510a

800

125268

600

125635

200

D2744

Manufactured

No

110

Each

52.0000

1

1

D2744

Cap

8214/01/23

Location

Loc Qty

Loc Code

LG001

52

100398

28

97543

24

D2600-3-BENT

Manufactured

No

110

Each

5.0000

1

1

D2600-3-BENT

Extrusion Bent

14-1-22

Location

Loc Qty

Loc Code

LG002

5

109789

5

110478

0

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Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

D2743 Manufactured No 160 Each 331.0000 8 8

D2743

Crossbolt Spacer

BE 14-01-28

Location	Loc Qty	Loc Code
LG001	331	
106245	9	
107359	68	
107907	122	
109799	132	

D2739 Manufactured No 160 Each 11.0000 1 1

D2739

350 I Beam

Location	Loc Qty	Loc Code
LG002	11	
109712	1	
109973	10	

D3490-3 Manufactured No 160 Each 160.0000 4 4

D3490-3

Cross Bolt Spacer

BE 14-01-28

Location	Loc Qty	Loc Code
LG001	160	
103883	14	
105603	3	
107913	63	
109933	80	

D3490-1 Manufactured No 160 Each 225.0000 4 4

D3490-1

Cross Bolt Spacer

BE 14-01-28

Location	Loc Qty	Loc Code
LG001	225	
107419	57	
109932	168	

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Work Order ID: 110472

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Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

Each

469.0000

38

AI S4-1032-225

Rivnut

Handwritten: 11/02/13

Location

Loc Qty

Loc Code

FG

30

M127028

30

Handwritten: M128179

Handwritten: 438

ST280

10

M127028

10

st555

429

M127092

429

D3793-3

Manufactured

No

230

Each

11.0000

1

1

D3793-3

Wearplate Aft

Handwritten: 11/02/13

Location

Loc Qty

Loc Code

FP001

11

104212

11

Handwritten: B110066

Handwritten: 41

AN8C35A

Purchased

No

230

Each

75.0000

1

1

AN8C35A

Bolt

Handwritten: 11/02/13

Location

Loc Qty

Loc Code

FG

4

121275

4

FP001

71

m126293

47

m127061

24

Handwritten: 11

D3793-1

Manufactured

No

230

Each

6.0000

1

1

D3793-1

Wearplate Fwd

Handwritten: 11/02/13

Location

Loc Qty

Loc Code

FP002

6

109205

6

Handwritten: B111 467 (X1)

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Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

D3488-041 Manufactured No

230 Each 4.0000 1 1

D3488-041

Blade Fitting LH

**

ll 12/20/13

Location

Loc Qty

Loc Code

FP001

4 B107196

xl

103877

4

D3794-3 Manufactured No

230 Each 17.0000 1 1

D3794-3

Gasket Aft

**

ll 12/20/13

Location

Loc Qty

Loc Code

FP001

17

B110910

xl

108413

17

AN6C44A Purchased No

230 Each 56.0000 4 4

AN6C44A

Bolt

**

ll 12/20/13

Location

Loc Qty

Loc Code

FG

2

M128319

xl

103964

2

ST340

50

123900

50

ST341

4

m127300

4

MS21083C8 Purchased No

230 Each 35.0000 1 1

MS21083C8

Nut

**

ll 12/20/13

Location

Loc Qty

Loc Code

ST319

35

M127813

xl

m127255

35

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Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

D3536-25

Manufactured No

230

Each

20.0000

1

1

D3536-25

Gasket Center

ll 12/02/26

Location

Loc Qty

Loc Code

FG

6

0113008

✓1

87053

2

95328

4

FP001

14

109206

14

D3631-1

Manufactured No

230

Each

12.0000

8

8

D3631-1

Washer

ll 12/02/26

Location

Loc Qty

Loc Code

FP001

12

1311516

✓8

107324

12

D3791-1

Manufactured No

230

Each

3.0000

1

1

D3791-1

Wearpad

ll 12/02/26

Location

Loc Qty

Loc Code

FP002

3

13110212

✓1

106144

3

NAS1149C0332R

Purchased No

230

Each

9,547.000

38

38

NAS1149C0332R

WASHER

ll 12/02/26

Location

Loc Qty

Loc Code

GA

1277

125654

1277

11127831

✓38

st510

8270

m126319

2770

m127306

2500

m127410

3000

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Work Order ID: 110472

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Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

D2745 Manufactured No 230 Each 129.0000 8 8

D2745

Bushing

all 12/02/13

Location

Loc Qty

Loc Code

ST017

129

B110526

x d

106847

5

107336

124

vd

AN3C5A

Purchased No

230 Each 164.0000 34 34

AN3C5A

Bolt

all 12/02/13

Location

Loc Qty

Loc Code

FG

5

M128057

v3d

122800

5

ST350

159

m127290

159

D3537-1

Manufactured No

230 Each 20.0000 3 3

D3537-1

Wearpad

all 12/02/13

Location

Loc Qty

Loc Code

FG

18

B111590

x3

79833

8

88562

10

FP001

2

108118

2

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Parent Item: D350-636-011

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Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0832R

Purchased

No

230

Each

359.0000

1

1

NAS1149C0832R

Washer

**

lll 11/02/20

Location

Loc Qty

Loc Code

ST292

359

122441

92

m114915

117

m125807

150

x1

AN3C6A

Purchased

No

230

Each

535.0000

4

4

AN3C6A

Bolt

**

lll 11/02/20

Location

Loc Qty

Loc Code

FG

10

122416

10

ST513

525

m125709

525

x1

NAS1611-013

Purchased

No

230

Each

16.0000

8

8

NAS1611-013

O-RING

**

lll 11/03/04

Location

Loc Qty

Loc Code

FP001

16

125445

16

11128376

x2

D3535-25

Manufactured

No

230

Each

13.0000

1

1

D3535-25

Wearplate Center

**

lll 11/02/20

Location

Loc Qty

Loc Code

FG

2

95077

2

FP002

11

106128

11

B110744

x1

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Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

D3794-1

Manufactured No

230

Each

13.0000

1

1

D3794-1

Gasket Fwd

all 14/02/20

Location

Loc Qty

Loc Code

FP001

13

B110316

X1

104620

1

108497

5

109207

7

MS21043-6

Purchased No

230

Each

268.0000

4

4

MS21043-6

NUT

all 14/02/20

Location

Loc Qty

Loc Code

FG

20

103693

20

ST315

248

m127255

248

V4

D3493-1

Manufactured No

250

Each

245.0000

2

2

D3493-1

Washer

DAS
28
9-89

14-03-4

DAS
31
9-89

Location

Loc Qty

Loc Code

FG

10

97201

10

ST051

235

105613

16

107916

60

109105

159

2x

***ONLY INSTALL IF INSTALLING ON APICAL
FLOAT SYSTEM***

December-20-13 9:07:09 AM

Shop Packet Print

Page 9

Picklist Print

Page 10

December-20-13 9:07:09 AM

Work Order ID: 110472

110472

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

35.0000

2 2

MS21083C8

**

DAS

14-03-4

Nut

DAS
31
9-89

Location

Loc Qty

Loc Code

ST319

35

128119

m127255

35

AN8C21A

Purchased

No

250

Each

45.0000

2 2

AN8C21A

**

DAS

Bolt

DAS
31
9-89

Location

Loc Qty

Loc Code

ST

2

124884

123966

2

ST505

43

m127061

43

NAS1515H3L

Purchased

No

230

Each

54.0000

4 4

NAS1515H3L

**

140226

Washer

Location

Loc Qty

Loc Code

FG

40

17127831

40

102472

40

ST297

14

124542

14

December-20-13 9:07:09 AM

Shop Packet Print

Page 10

Picklist Print

December-20-13 9:07:09 AM

Page 11

Work Order ID: 110472

110472

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13

Required Date: 1/03/14

Start Qty: 1.00

Required Qty: 1.00

D2741

Manufactured No

250

Each

39.0000

1 1

D2741

Blade

**

DAS
28
9-89

14-03-4

Location

Loc Qty

Loc Code

FG

11

100664

5

85480

1

98323

5

ST466

28

107206

28

110710

DAS
31
9-89

D3532-1

Manufactured No

250

Each

86.0000

2 2

D3532-1

Spacer

**

DAS
28
9-89

Location

Loc Qty

Loc Code

ST054

86

100519

26

109803

60

2X

DAS
31
9-89

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

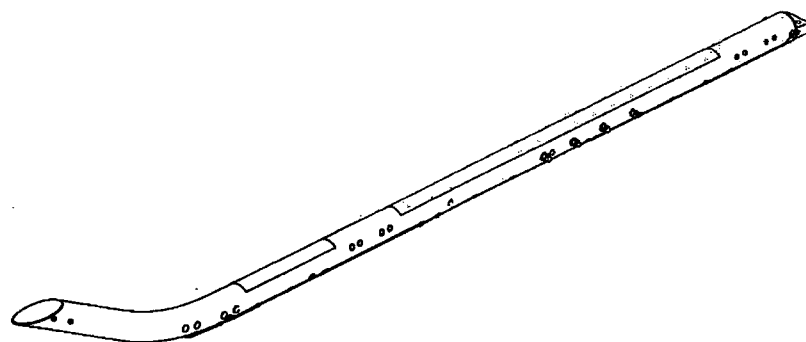
- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
 STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
 OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
 MINIMUM YIELD TENSILE STRENGTH = 35 KSI
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
 FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

110472 MLS

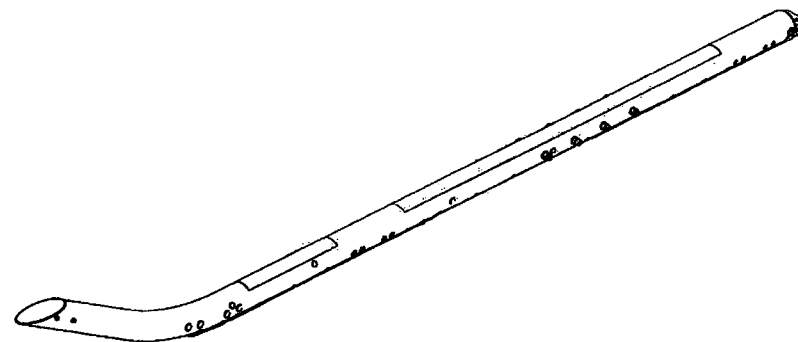
13-12-20

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2013-08-13

G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	13	KENT, WA	
CHECKED	13	DRAWING NO.	REV. G
MFG. APPR.	13	D2750	SHEET 1 OF 11
APPROVED	13	TITLE	SCALE
DE APPR.	13	350 SKIDTUBE ASSEMBLY	NTS
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D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

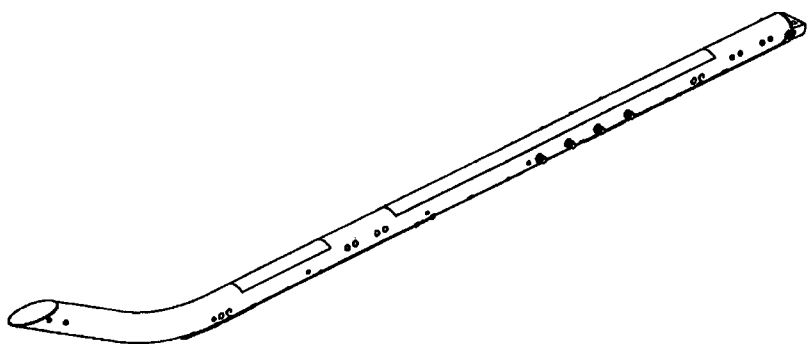
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MR

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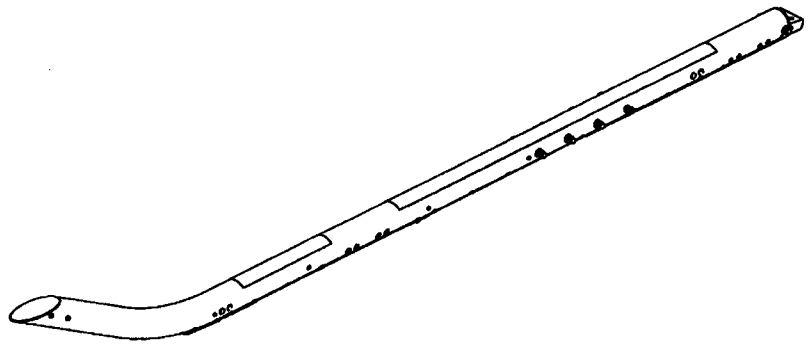
8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A



D2750-043 350 SKIDTUBE ASSEMBLY, LH



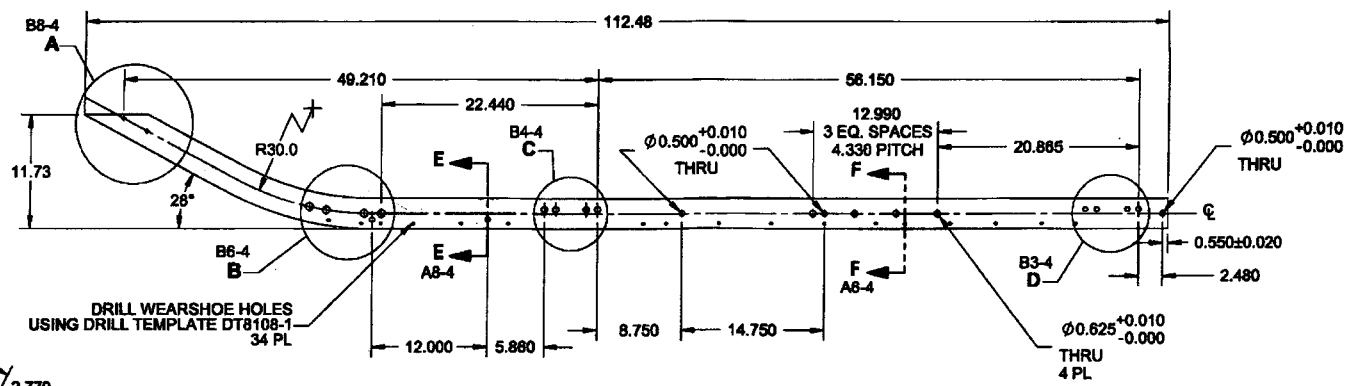
D2750-044 350 SKIDTUBE ASSEMBLY, RH

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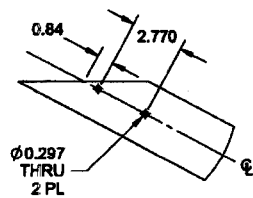
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8 7 6 5 4 3 2 1

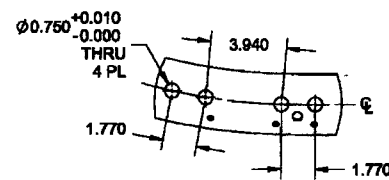
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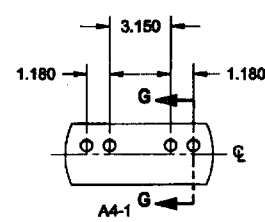
D2750-1 LH SKIDTUBE



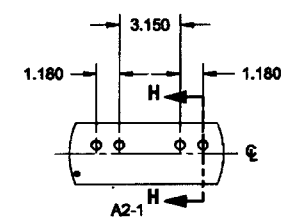
DETAIL A
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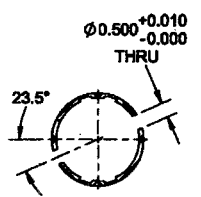
DETAIL B
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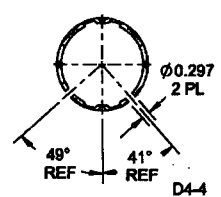
DETAIL C
SCALE 2X



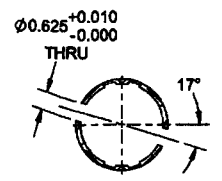
DETAIL D
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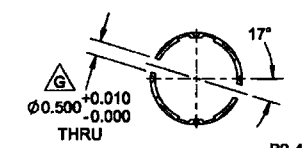
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL

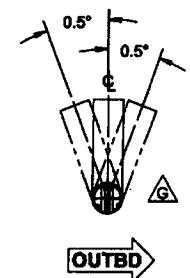
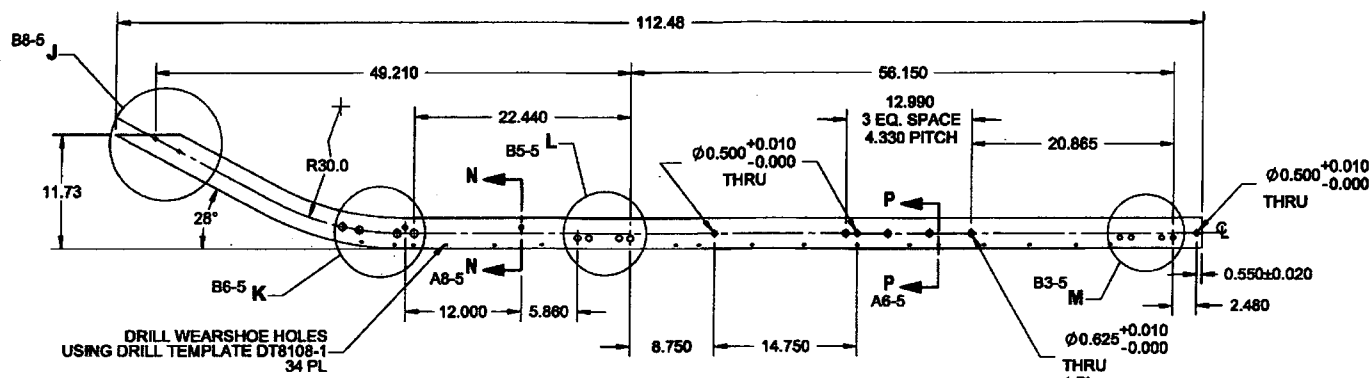


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SCALE 3X, 4 PL

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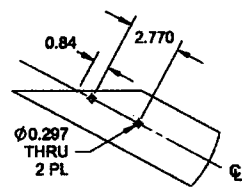
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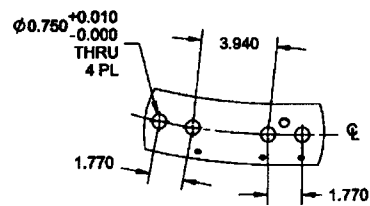


MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

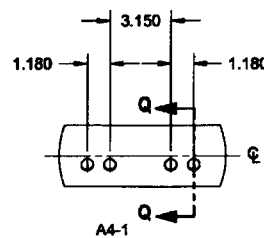
D2750-2 RH SKIDTUBE



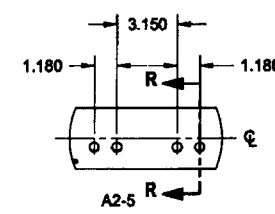
DETAIL J
SCALE 2X



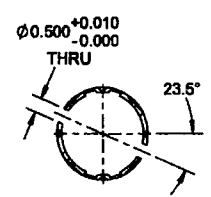
DETAIL K
SCALE 2X



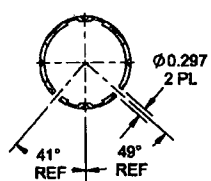
DETAIL L
SCALE 2X



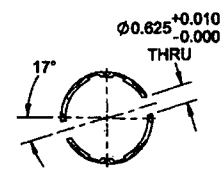
DETAIL M
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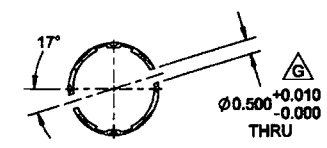
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SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL

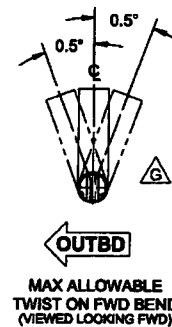
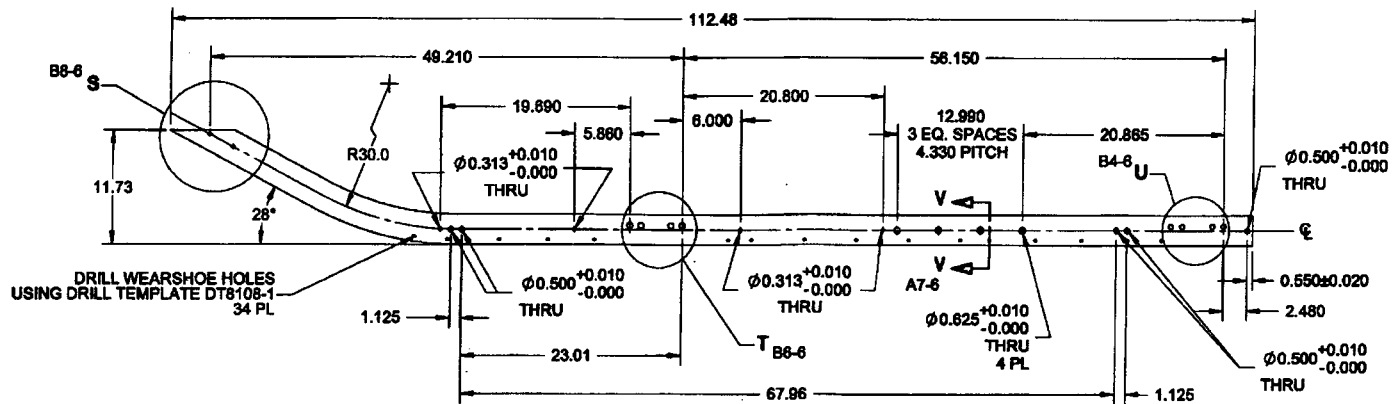


SECTION R-R
SCALE 3X, 4 PL

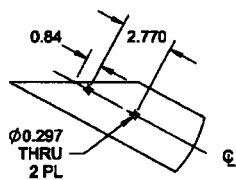
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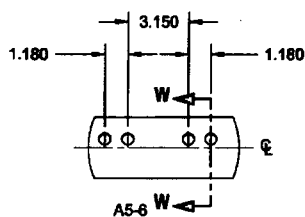
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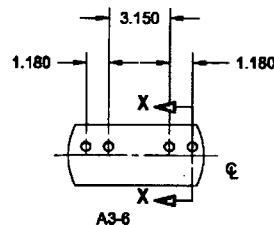
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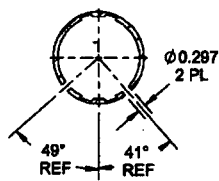
DETAIL S
SCALE 2X
D8-6



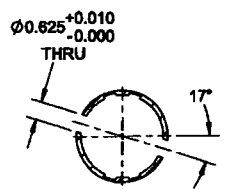
DETAIL T
SCALE 2X
C5-6



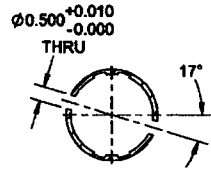
DETAIL U
SCALE 2X
D3-6



SECTION V-V
SCALE 3X, 17 PL
C4-6



SECTION W-W
SCALE 3X, 4 PL
B8-6

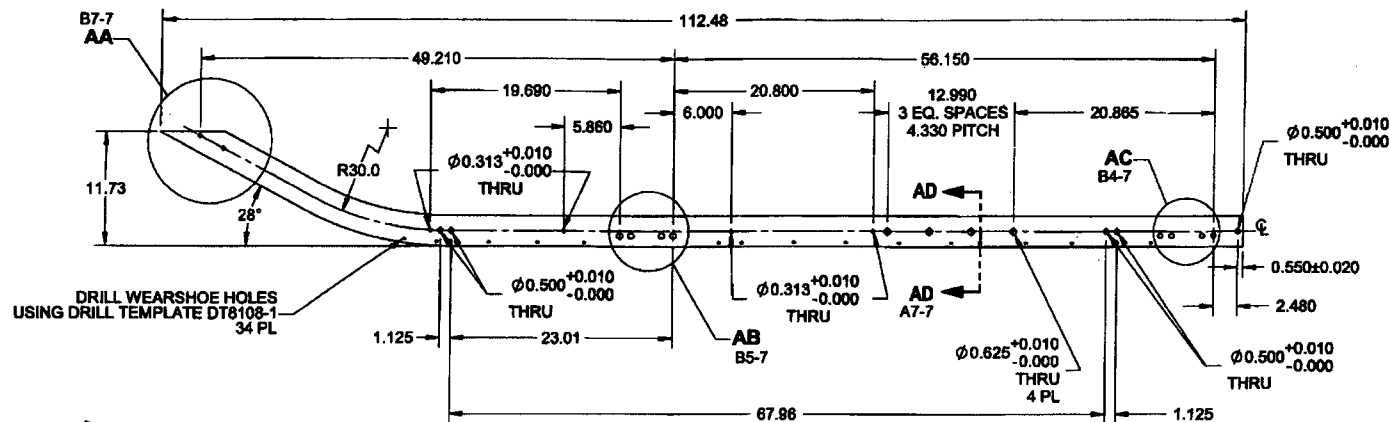


SECTION X-X
SCALE 3X, 4 PL
B4-6

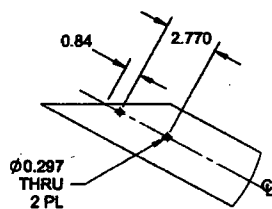
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2013-08-13
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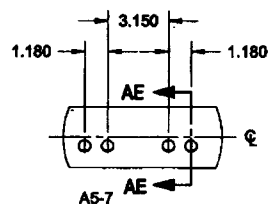
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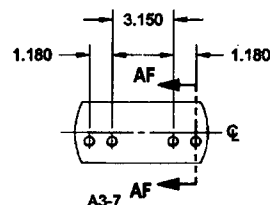
D2750-4 RH SKIDTUBE



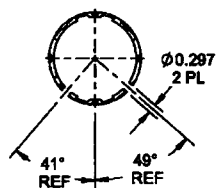
DETAIL AA
D7-7
SCALE 2X



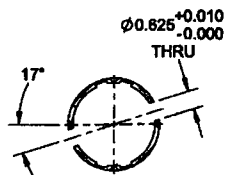
DETAIL AB
C4-7
SCALE 2X



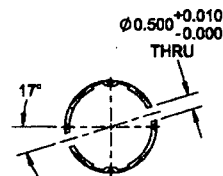
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SCALE 2X



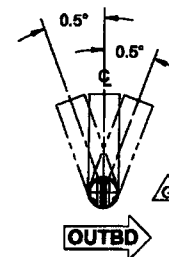
SECTION AD-AD
D3-7
SCALE 3X, 17 PL



SECTION AE-AE
B6-7
SCALE 3X, 4 PL



SECTION AF-AF
B4-7
SCALE 3X, 4 PL



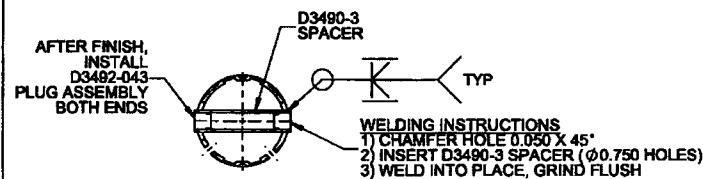
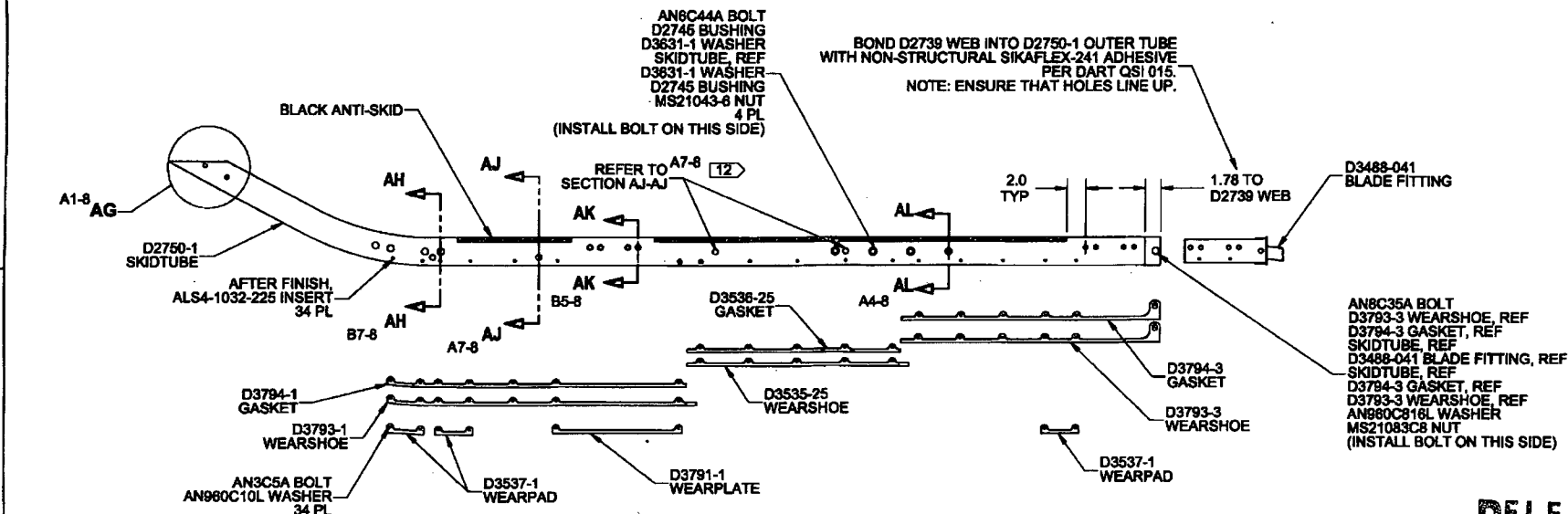
**MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)**

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2013-08-13
MP

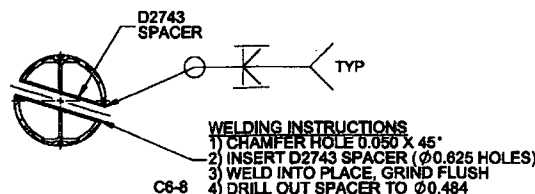
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2750	SHEET 7 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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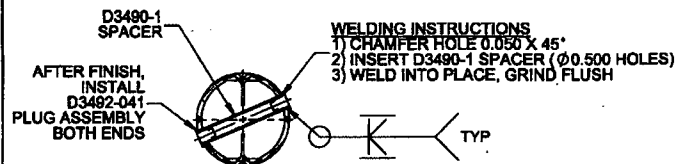
D2750-041 350 SKIDTUBE ASSEMBLY, LH



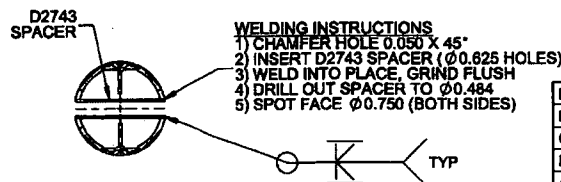
SECTION AH-AH
SCALE 3X, 4 PL



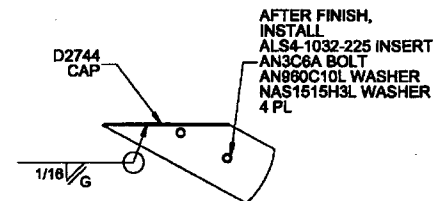
SECTION AK-AK
SCALE 3X, 4 PL



SECTION A-I-AI
SCALE 3X, 4 PL

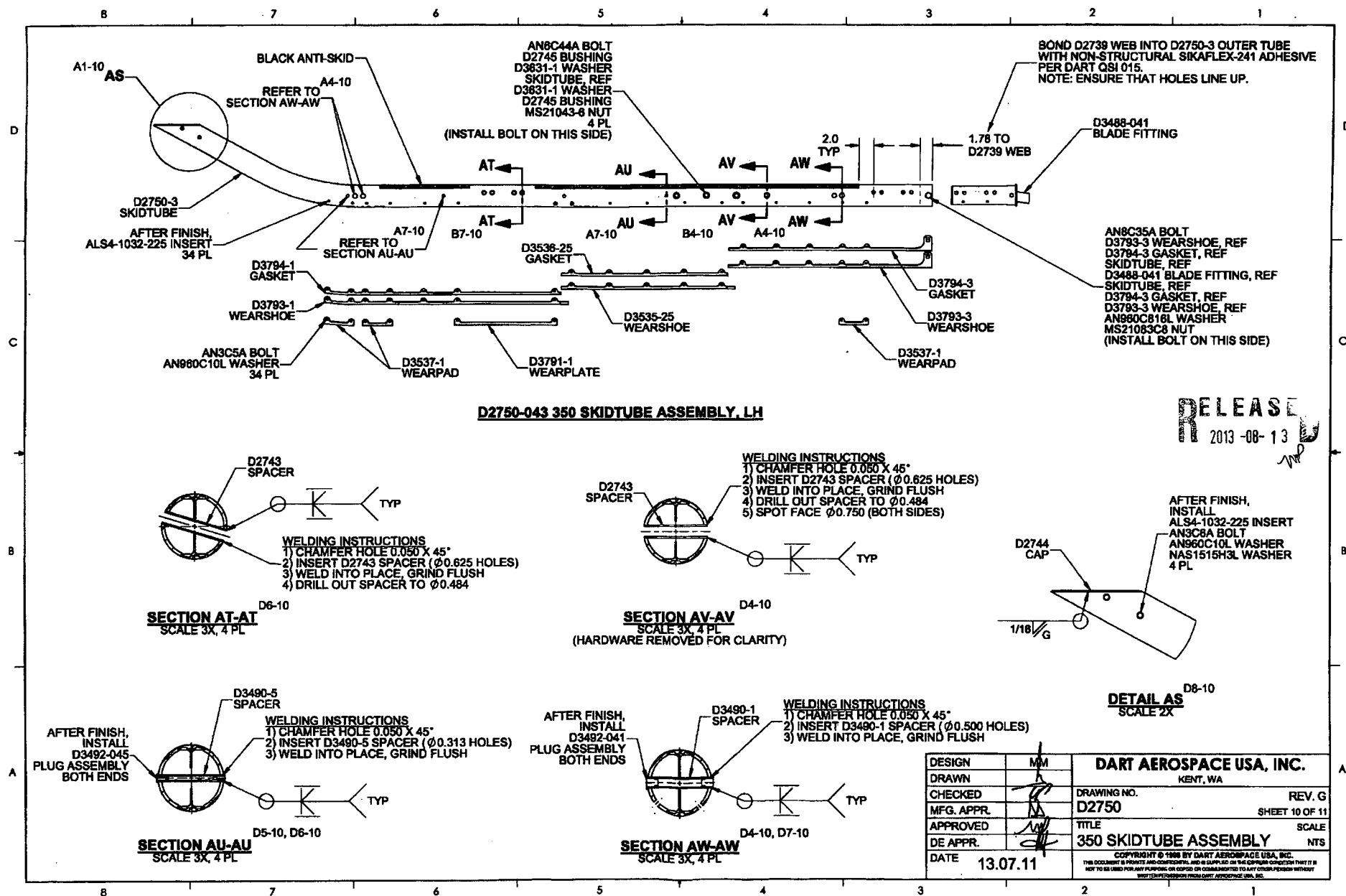


SECTION AL-AL
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

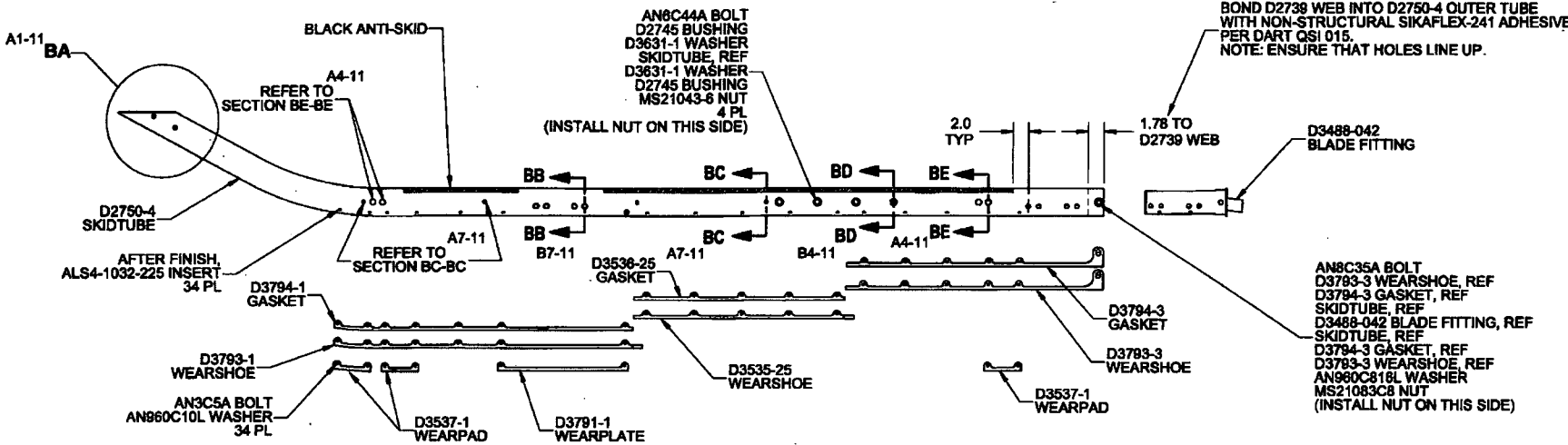


DETAIL AG
SCALE 2X

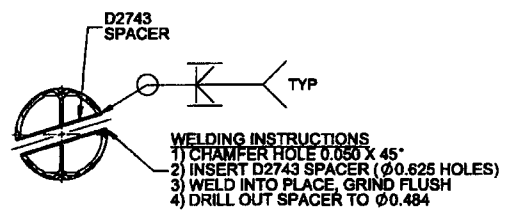
DESIGN	MM	DART AEROSPACE USA, INC.	
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MFG. APPR.		D2750	SHEET 8 OF 11
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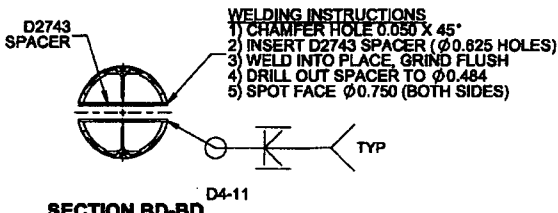
8 7 6 5 4 3 2 1



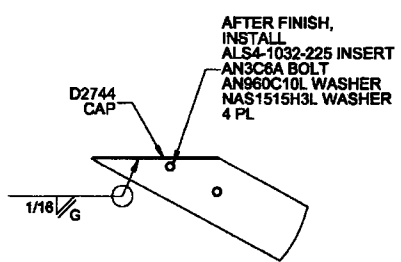
D2750-044 350 SKIDTUBE ASSEMBLY, RH



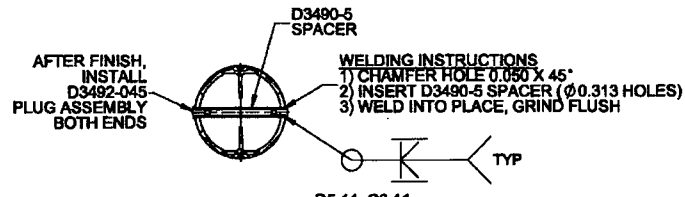
SECTION BB-BB
SCALE 3X, 4 PL



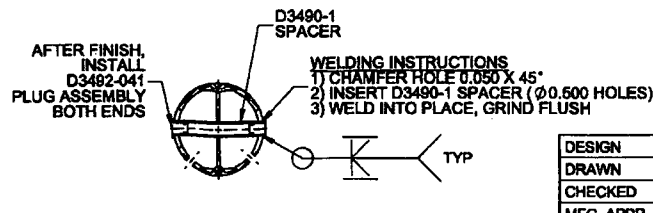
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



DETAIL BA
SCALE 2X



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL

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RELEASED
2013-08-13

No. 337

**AWS D17.1/D17.1M:2010
SKIDTUBE WELDING TEST RECORD**

Name: Barclay Elliott
Job #: B109371
Part #: D350-636-012
Description: 350 skid tube
Welding Process: TIG [☒] MIG []
Base Material: Aluminum
Current: AC [☒] DC []

TEST REQUIREMENTS AND RESULTS

Visual:	pass [<input checked="" type="checkbox"/>] fail []
Penetration:	pass [<input checked="" type="checkbox"/>] fail []
Fusion:	pass [<input checked="" type="checkbox"/>] fail []
Cracks:	pass [<input checked="" type="checkbox"/>] fail []
Overlap (cold lap)	pass [<input checked="" type="checkbox"/>] fail []
Undercut:	pass [<input checked="" type="checkbox"/>] fail []
Pin holes:	pass [<input checked="" type="checkbox"/>] fail []
Porosity (surface):	pass [<input checked="" type="checkbox"/>] fail []
Coloration:	pass [<input checked="" type="checkbox"/>] fail []
Burn through:	pass [<input checked="" type="checkbox"/>] fail []

Qualifier: DAS
9
S-88 Date of Test Coupon: 13-12-03
Welder: Barclay Elliott Date of Test Coupon: 13-12-03

The above named individual is qualified to weld in accordance with AWS D17.1/D17.1M:2010.

Work Order ID 110472

110472

Page 1

December-20-13 9:07:05 AM

Item ID: D350-636-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube LH Aerazur / Apical Cylindrical Compat.

Start Date: 12/20/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/03/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 13-12-20 Tooling:

Date:

Run Start *NR1*

QC: _____

Date: _____ SPC (Y/N): _____

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2750-041	G
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MLJ

0.00

MLJ 14-03-04

100

100

DOCUMENT CONTROL

DC

Memo

record fwd angle:

89.5°

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 007

DD

14-1-22